HAAS 1

HAAS CNC vertical machine #1

Memo

DWG REV:

FOLIO REV:

MACHINE AS PER FOLIO FA874 AND DWG

DEBURR

W/O:			V	ORK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR:	Yes N	lo DQA:		Date:	
		esolution:								
NCR:			WORK OR	DER NON-CONFORM	ANCE	(NCR)	,,,,,,,,,,,,,-			
DATE	STEP	Description of NC	Description of NC Corrective Action Sec			<u></u>	Verifica	tion	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	С	Chief Eng	QC Inspector
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Page 2

Tuesday, October 26, 2010 3:05:44 PM

Item ID:

D4016-3

Revision ID: Item Name:

Hinge Half, Lid

Start Date:

10/26/2010

Required Date: 11/1/2010

Start Qty: 6.00 Req'd Qty: 6.00



Customer:

Cust Item ID:

Reference:

Approvals:

Sequence ID/

Work Center ID

QC:

Process Plan:

Date: _____

Date:_____ **Tooling:**

Accept

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Date:

Date:

Tool # Plan Code Accept Qty

Run

Reject Qty

Setup Start

Stop

Start

Stop

Reject Insp. Number Stamp

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

H.A

10/11/03

130 QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

and 10/11/04

160

Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00

Packaging

W/O:		W	ORK ORDER CHANG	ES	····					
DATE	STEP	PRO	CEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: `	Yes N	o DQA	\:	Date: _	1
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DATE	STEP	Description of NC Corrective Action			on B	: Ó	Verific		Approval	Approval
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Work Order ID 63256

Tuesday, October 26, 2010 3:05:44 PM



Page 3

Item ID:

D4016-3

Accept



Setup Start



Revision ID:

Item Name:

Hinge Half, Lid

Start Date:

10/26/2010

Start Qty: 6.00

Operation

Description

Required Date: 11/1/2010

Req'd Qty: 6.00



Date:

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Start Run

Stop

Stop

Sequence ID/

Work Center ID

170

Date:

Tool # Plan Code

Accept Reject Qty Qty

Reject Number

Insp. Stamp

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

N/O:		W	ORK ORDER CHANG	GES						
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No	:	PAR #:	Fault Cat	egory:	NCF	R: Yes	No DQA	Date:		
	Resolution:		Dispositi	on:	QA:	N/C CI	osed:		Date:	
NCR:		,	WORK ORE	DER NON-CONFORM	ANCE	(NCF	₹)			
DATE	STEP	Description of NC	Corrective Action Section B					ation	Approval	Approval
	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date		on C	Chief Eng	QC Inspector
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Picklist Print

Tuesday, October 26, 2010 3:05:48 PM

Work Order ID: 63256

Parent Item:

D4016-3

Parent Item Name: Hinge Half, Lid



Start Date: 10/26/2010

Required Date: 11/1/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	14.5875	0.08	0.505263			

IPP Rev:B as

304 bar 1.00 x 1.00

Location Loc Qty Loc Code MAT54 14.58747768 **->** 113290 14.5874777

0.5052 t B.A 10/11/02

W/O:			W	ORK ORDER CHANG	SES				
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No D G	A:	Date: _	
•	R	esolution:	Disposit	ion:	QA: N/C (Closed: _		Date: _	
NCR:		\	WORK OR	DER NON-CONFORM	ANCE (NC	R)			
DATE	CTED	Description of NC Corrective Action			Section B Verific			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	43254
Description: Hinge Half, Lid	Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	0.875	~		Vern	GA-01
0.13	+/-0.030	0.126	~		M	11
0.250	+/-0.010	0.251	~		N I	, ,
R0.03	+/-0.030	R0.030	~		R.G	ref,
0.13	+/-0.030	0.125	V		Vein	GA-01
0.50	+/-0.030	0.499	~		[1	(1
0.63	+/-0.030	0.625	<u></u>		(1	11
0.563	+/-0.010	0.562	~		()	ſ,
Ø0.257	+0.006/-0.001	Ø0.258	~		17	(1

Measured by: H. A	Audited by:	Preliminary Approval:
Date: 10 11 03	Date: 10/11/03	Date:

Rev	Date	Change	Revised by	Approved
Ā	10.06.07	New Issue	KJ (PK)	

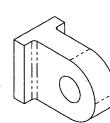
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Part No	•	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	:	QA: N/C C	losed:		Date: _	
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DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval
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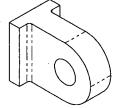
SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER No. 4325





D4016-1 HINGE HALF, BASE

D4016-3 HINGE HALF, LID

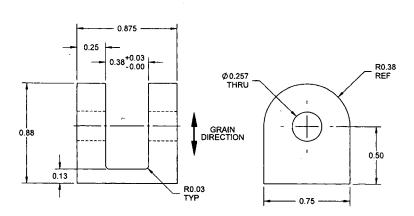
D4016-5 HINGE HALF, LIGHT LID



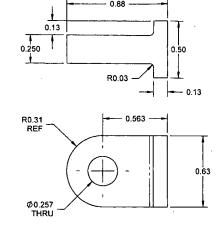
Α	NEW IS	SUE		JPH	10.01.29					
REV.			DESCRIPTION	BY	DATE					
DESIGN	4	AJS	DART AEROS	DART AEROSPACE LTD						
DRAWN	1	AJS	HAWKESBURY, ONTARIO, CANADA							
CHECK	ED.	ω	DRAWING NO.	REV. A						
MFG. A	PPR.	12/2	D4016		SHEET 1 OF 2					
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W/O:			V	ORK ORDER CHAN	IGES		· · · · · · · · · · · · · · · · · · ·			
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D4016-1 HINGE HALF, BASE



GRAIN DIRECTION

D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	AJS					
CHECKED	0	DRAWING NO.	REV. A			
MFG. APPR.	<i>N</i>	D4016	SHEET 2 OF 2			
APPROVED	10	TITLE	SCALE			
DE APPR.	-#-	BASKET HINGE	NTS			
DATE 10.01.29		COPYRIGHT © 2010 BY DARY AEROSPACE LYD THIS DOCUMENT IN PRIVATE AND COPYRIGHTAIN, AND B SUPPLIED ON THE EXPERTS OCCORDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPYRIGHTAIN FOR SUPPLIED ON COMMUNICATED TO ANY OTHER PURPOSE WITHOUT WHITE PRIVATE PRIVATE PRIVATE PRIVATE DAYS AND ANY PURPOSE OF LYD. TO SEE THE PRIVATE PRIVAT				

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-3: 0.04 lbs
-5: 0.01 lbs

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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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